

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014291**Date Inspected:** 21-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	Orthotropic Box Girder(OBG)	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment 7AW ~ 7CW (Corner Assembly)

This Quality Assurance (QA) Inspector witnessed final tension verification for Corner Assembly at Panel Point (PP) 47.5 and PP 60.5 for Segment 7AW ~ 7CW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00356 Dated May 21, 2010.

Bolt sizes used were M22 x 55 RC Set# DHGM220044 and final torque required was 473 N-m.

Bolt sizes used were M22 x 85 RC Set# DHGM220096 and final torque required was 583 N-m.

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

Bolt sizes used were M22 x 60 RC Set# DHGM240014 and final torque required was 567 N-m.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bolt sizes used were M22 x 120 RC Set# DHGM240009 and final torque required was 567 N-m.

Bolt sizes used were M22 x 80 RC Set# DHGM240011 and final torque required was 533 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-666.

Note: Except PP51 ~ PP52, PP55~PP56, PP58~PP59

Segment 7CE ~ 7DE (Longitudinal Diaphragm)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Longitudinal Diaphragm to Longitudinal Diaphragm at E3 and E4 (North and South side) at Panel Point (PP) 55 and PP 56 for Segment 7CE to 7DE. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00354 Dated May 21, 2010

Bolt sizes used were M24 x 70 RC Set# DHGM240003 and final torque required was 543 N-m and

Bolt sizes used were M24 x 95 RC Set# DHGM240021 and final torque required was 540 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-666.

Segment 7AW ~ 7EW

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray at Panel Point (PP) 47.5 to PP 61 for Segment 7CW ~7EW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00343 Dated May 7, 2010

Bolt sizes used were M19 x 55 RC Set# DHG60580 and final torque required was 340 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

Segment 7AW ~7BW

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Manikandan Inspection for the following Segment 7AW~ 7BW from Panel Point 47.5 to PP 52

Corner Assembly Cope Holes dimension measurements at PP 47.5 to 52 Cross Beam and Counter Weight side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
